



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2801-042
Job Sheet 175546



Part No: D2801-042

Job Qty: 1 ea

Part Name: Step Assembly RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 5/18/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D2801 REV:A1 IPP REV:A 14.04.15 NEW ISSUE DD VERF:JLM,

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/17/18	0.00	0.00	Start Up Large Fab-4		DG 2018-04-24
100	Large Fab	1 pcs		5/17/18	0.00	1.47	Large Fab 8		DG 2018-04-29
110	QC	1 pcs		5/17/18	0.00	0.00	QC6		CPL
120	Large Fab	1 pcs		5/17/18	0.00	1.47	Large Fab 2		CPL
130	QC	1 pcs		5/17/18	0.00	0.00	QC9		10-05-03
140	QC	1 pcs		5/17/18	0.00	0.00	QC5		10-05-03
150	HandFinish	1 pcs		5/17/18	0.00	0.37	HandFinish1		SA 18-05-04
160	QC	1 pcs		5/17/18	0.00	0.00	QC7-1		CPL
170	Large Fab	1 pcs		5/17/18	0.00	1.47	Large Fab 2		CPL
180	QC	1 pcs		5/17/18	0.00	0.00	QC10		14 2018-05-10
190	QC	1 pcs		5/17/18	0.00	0.00	QC5		14 2018-05-10
191	HandFinish	1 pcs		5/17/18	0.00	0.37	HandFinish2		SA 18-05-10
200	Powdercoat	1 pcs		5/17/18	0.00	0.24	Powdercoat1		BR 18-05-10
210	QC	1 pcs		5/17/18	0.00	0.00	QC3		BEB 18-05-11
220	HandFinish	1 pcs		5/18/18	0.00	0.37	HandFinish4		BEB 18-05-11
230	QC	1 pcs		5/18/18	0.00	0.00	QC5		38
240	Packaging	1 pcs		5/18/18	0.00	0.00	Packaging3-1		Chm
250	QC21-SA	1 Ea		5/18/18	0.00	0.00	QC21		Chm

Part Op 100 - 1-Cut D2622 extrusion to 86.15" long as per Dwg D2801 2-Deburr and bevel ends for welding

Descriptions: 120 - ***Press fit bushing before weldig*** 1-Weld Arms as per Dwg D2801 2-Weld (1) Cap as per Dwg D2801 3-Grind end cap welds flush

170 - 1-Weld last arm as per Dwg D2801 2-Weld last end cap as per Dwg D2801 3-Grind end cap welds flush Inspect for foreign object per QSI 024

191 - ***Touch up step with alodine per qsi 005 prior to powder coat***

200 - START TIME: 1:30 OVEN TEMPERATURE: 300° FINISH TIME: 2:00

220 - Wing Walk per Dwg D2801 and QSI 005 4.4

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	5046116
D2734	Step End Plate	2 Ea (2 ea)	90-Start up Operation	5012001
D2802-2	Arm	2 (2 ea)	90-Start up Operation	F116446
D2808	Spacer	2 Ea (2 ea)	90-Start up Operation	F155607

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	211	0
	D2734	2	9	0
	D2802-2	2	0	0
	D2808	2	18	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 10:35 AM dart.lacelle.linda

DQA: _____ Date: _____



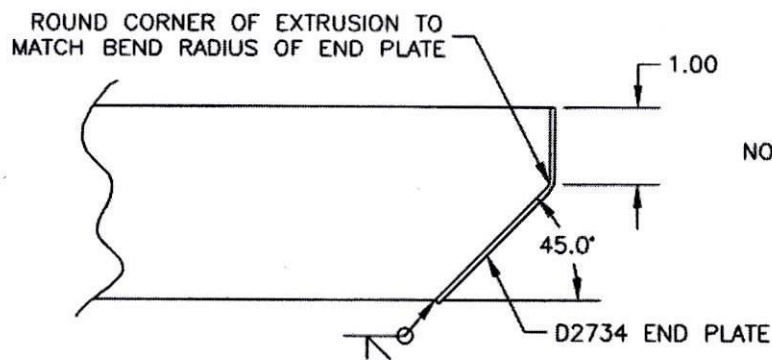
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: **DAS 53** Date: **MAY 30 2018**Work Order update only ☐

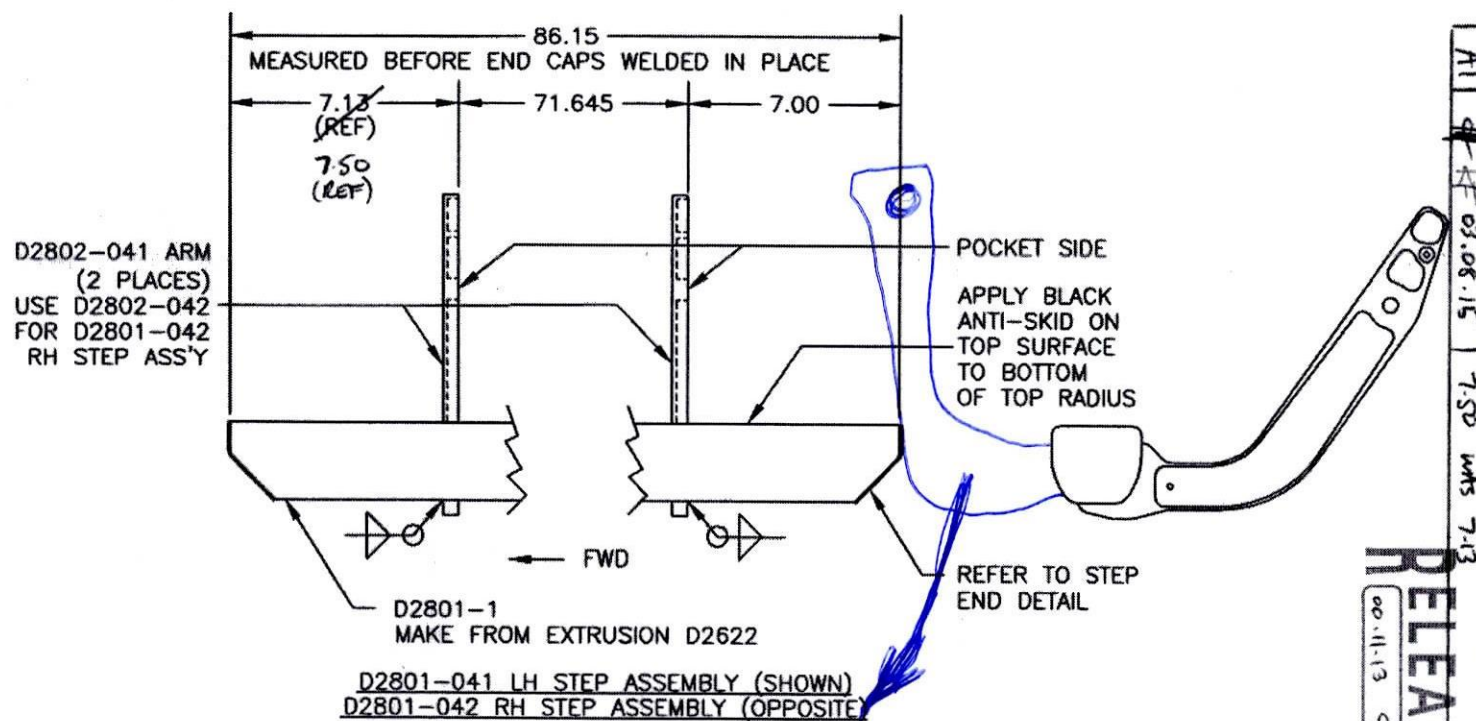
Work Order: <u>9-89 175546</u> Part No. <u>175546</u> NCR No. <u>18-6882</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																										
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Description Work Order Deviation MS206 DIAD4WZ R# M138336-7 Acceptable. Some feature as on other steps. No effect on step strength. Ø 0.129 CSK 0.225 x 100 OPTIONAL VENT HOLE for welding Located on Surface - Plug with MS206 DIAD4WZ rivet AFTER welding Prior to Finish		Disposition Completed By <u>CPL 18/5/8</u> Lead hand / Supervisor Approval Verification <u>CPC 18/5/8</u> QC / QA Coordinator Approval <u>PD 18-05-30</u>																																																																																										
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DART

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
00.11.03	STEP WELDMENT	SHEET 1 OF 1
A	00.11.03	SCALE
A1	03.06.15	NTS
	NEW ISSUE	
	7.50 wts 7.13	

RELEASED
00.11.13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

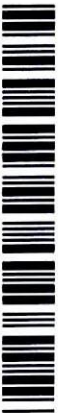
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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Email: sales@dartaero.com
www.dartaero.com



Container No: S064769



Part: D2801 - 042

Job No: 175546

Serial No/Batch: S064769

Revision: A1

Inspector:

Date: 04/24/18

FAULT CATEGORY

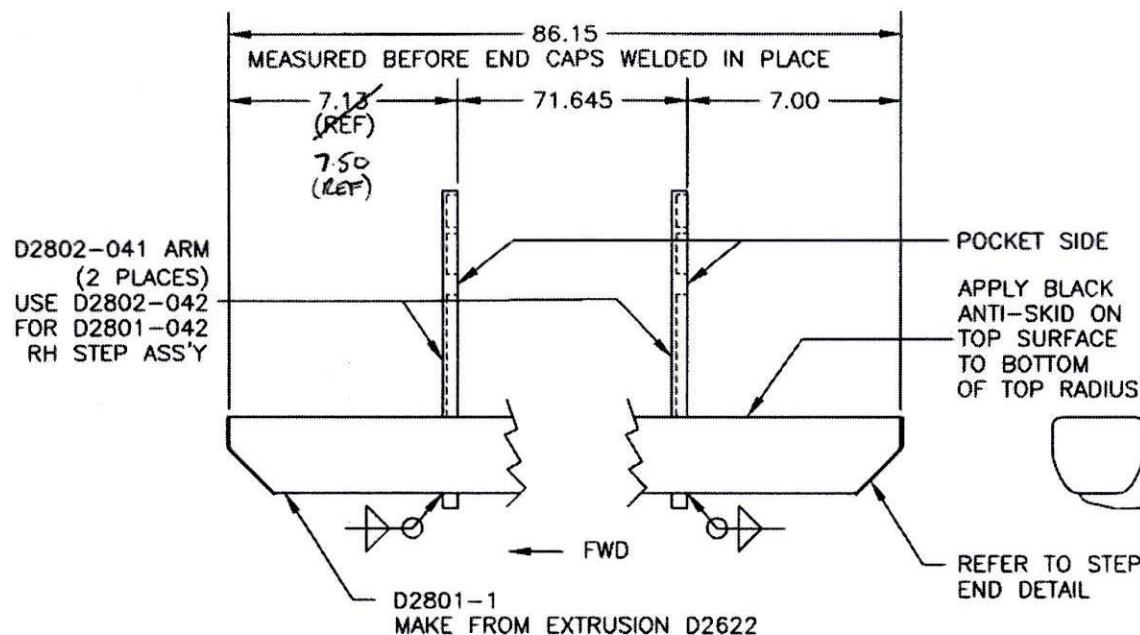
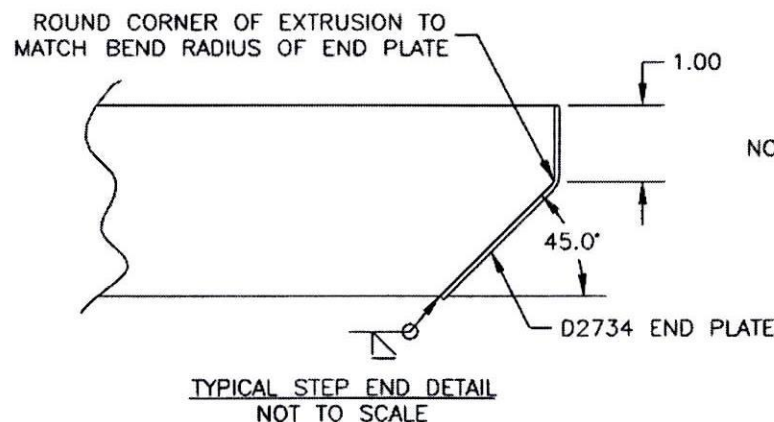
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
00.11.03	STEP WELDMENT	SHEET 1 OF 1
A	00.11.03	SCALE
A1	03.08.15	NTS
	7.50 WTS 7-13	

RELEASED
00.11.13

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6)

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